

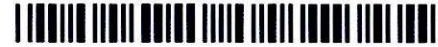


Dart Aerospace Ltd.
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646.3301

Job Sheet 203271



Part No: 646.3301

Job Qty: 4 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3300 REV:A IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER DWG
NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		12/12/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



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Container No: S263563



Part: 646.3301

Job No: 203271

Serial No/Batch: S263563

Revision: A

DAS

41

9-80

MAR 23 2020

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	Small Fab - 2 - B4B	4 pcs	12/12/19	0.00 5.56	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	DAS
					Small Fab - 6 - B4B	41 MAR 17 2020
					Small Fab - 7 - B4B	9-89
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
130	QC 5	4 pcs	12/12/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS
					QC 5 - 61	MAR 24 2020 40
					QC 5 - 81	9-89
140	Packaging 3-1 - Stock - B4B	4 pcs	12/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

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				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150	QC 21 - SA	4 pcs	12/12/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - Pick Kit

Descriptions: 120 - Small Fab - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7. exp. date: 5253009 exp 2/21

130 - QC5- Inspect part completeness to step on W/O

140 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5223451
646.3311	RH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5224197
646.3312	Center Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5222136
646.3313	Upper Guide	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5244230(1) 5222200(3)
646.3314	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5250736 5193366
646.3315	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5248682 5170730
646.3316	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5247752 5192084
AN3-12A	Bolt	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	5166926
AN3-14A	Bolt	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	5112900
MS21042L08	Nut	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5234230(1) 5250462
MS21042L3	Nut	12 Ea (3 ea)	110-Packaging 1 - Pick Kit	5248081 5248985
MS27039-08-19	Screw	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5250577 5248988
NAS1149F0332P	Washer (AN960-10L)	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	5222884 5232779
NAS1149FN832P	Washer (AN960-8)	144 Ea (36 ea)	110-Packaging 1 - Pick Kit	5222884 5248080

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3310	4	25	0
	646.3311	4	25	0
	646.3312	4	26	0
	646.3313	4	22	0
	646.3314	4	14	0
	646.3315	4	16	0
	646.3316	4	17	0
	AN3-12A	8	122	0
	AN3-14A	4	175	0
	MS21042L08	72	939	0
	MS21042L3	12	2,396	0
	MS27039-08-19	72	1,010	0
	NAS1149F0332P	24	4,820	0
	NAS1149FN832P	144	2,082	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					